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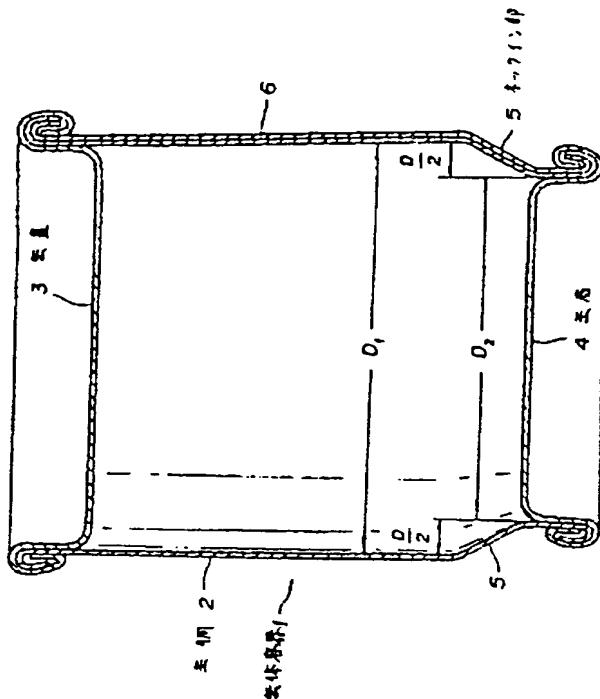
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TITLE : MANUFACTURE OF CAN BODY CONTAINER



ABSTRACT : PURPOSE: To prevent the generation of wrinkles in the vicinity of the side seam part of a can shell by forming a neckin part on the can shell so that the necking amount of the can shell and the hardness of a can shell forming material may become within a forming range found experimentally.

CONSTITUTION: A can body container 1 is made by fastening a can cover 3 and can bottom 4 to both opening ends of the can shell 2 where a nickin part 5 is formed. In this case, the hardness of the steel material for can shell 2 is adjusted according to the necking amount D expressed by the diameter difference D₁-D₂ in the part not subjected to necking of the can shell 2 and the part subjected to necking. In case of the necking amount D being $\leq 2.8\text{mm}$ and $\leq 8.0\text{mm}$, the steel stock coming within the range of $50\sim 75.0 \times D^{-0.181}$ hardness in Rockwell hardness HR30T is used. Also in case of the necking amount being $\leq 2.8\text{mm}$, the steel stock coming within the range of $50\sim 76$ hardness in Rockwell hardness HR30T is used. The wrinkle generation in the vicinity of a side seam part can thus be prevented.

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